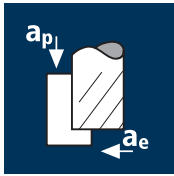


Application



Material

Wrought aluminium
Construction aluminium



Unalloyed copper



Thermoplastics



Cast aluminium



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	3	350	0.065	18.000	0.900	18570	3620	58.7
8.00	3	350	0.080	24.000	1.200	13925	3340	96.3
10.00	3	350	0.100	30.000	1.500	11140	3340	150.4
12.00	3	350	0.120	36.000	1.800	9285	3340	216.6
16.00	3	350	0.130	48.000	2.400	6965	2715	312.8
20.00	3	350	0.150	60.000	3.000	5570	2505	451.2
6.00	3	220	0.050	18.000	0.900	11670	1750	28.4
8.00	3	220	0.065	24.000	1.200	8755	1705	49.2
10.00	3	220	0.080	30.000	1.500	7005	1680	75.6
12.00	3	220	0.095	36.000	1.800	5835	1665	107.8
16.00	3	220	0.105	48.000	2.400	4375	1380	158.8
20.00	3	220	0.120	60.000	3.000	3500	1260	226.9
6.00	3	600	0.065	18.000	0.900	31830	6205	100.6
8.00	3	600	0.080	24.000	1.200	23875	5730	165.0
10.00	3	600	0.100	30.000	1.500	19100	5730	257.8
12.00	3	600	0.120	36.000	1.800	15915	5730	371.3
16.00	3	600	0.130	48.000	2.400	11935	4655	536.3
20.00	3	600	0.150	60.000	3.000	9550	4295	773.5
6.00	3	280	0.065	18.000	0.900	14855	2895	46.9
8.00	3	280	0.080	24.000	1.200	11140	2675	77.0
10.00	3	280	0.100	30.000	1.500	8915	2675	120.3
12.00	3	280	0.120	36.000	1.800	7425	2675	173.3
16.00	3	280	0.130	48.000	2.400	5570	2170	250.3
20.00	3	280	0.150	60.000	3.000	4455	2005	361.0